

(19)



Europäisches Patentamt
European Patent Office
Office européen des brevets



(11) Publication number:

0 416 751 A2

(12)

EUROPEAN PATENT APPLICATION

(21) Application number: 90308680.9

(51) Int. Cl.⁵: G01F 23/26

(22) Date of filing: 07.08.90

(30) Priority: 06.09.89 GB 8920130

(43) Date of publication of application:
13.03.91 Bulletin 91/11(84) Designated Contracting States:
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(84) BE CH DE FR IT LI NL SE

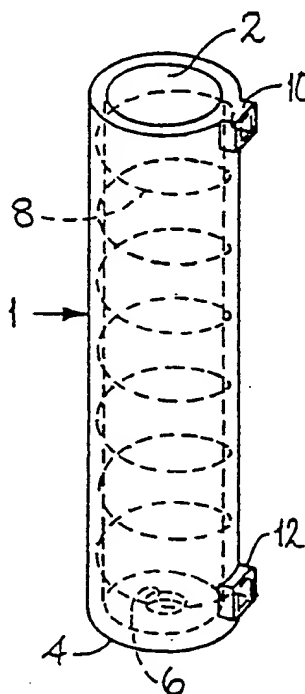
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(54) Sensing device.

(57) A sensor for sensing the level of adhesive medium in a dispensing device, which sensor comprises:

- (a) a coil which is adapted to surround a dispensing device for dispensing adhesive medium at an adhesive dispensing station;
- (b) means for connecting the coil to the input of an oscillator;
- (c) detector means for detecting the frequency of the output of the coil;
- (d) conversion means to perform a frequency to voltage conversion on the varying frequency detected at the detector means (c);
- (e) analogue to digital conversion means to convert the signal from the frequency to voltage conversion means (d) into a form which can be compared with a calibration scale obtained by measuring the signals generated at the output of the coil, when the coil is surrounding a dispensing device containing at least two different known quantities of adhesive medium; and
- (f) display means for displaying the result of this comparison.

The sensor can give information to the machine operator as to when the adhesive is about to run out, or to 30 indicate how many more bonding cycles can be performed before the dispensing device has to be replaced or refilled.

**Fig. 1****EP 0 416 751 A2**

tivity of the core of the coil. As the level of adhesive in the dispenser changes, so does the permittivity of the core, leading to a change in the frequency of the oscillations within the coil.

The invention will now be further described with reference to the accompanying drawings, in which;

Figure 1 is a view of a coil for use in a sensor according to the invention,

Figure 2 is a block diagram of a circuit for sensing the level of adhesive in a dispensing device, and

Figure 3 is a graph of the voltage against frequency curve derived from the frequency to voltage converter.

As can be seen from Figure 1, a plastics sheath 1 is in the form of a tube, with a first open end 2 and a second end 4 which is partially closed leaving a central hole 6 of smaller diameter than the tube. A coil 8 of wire is embedded in the plastics sheath 1 and is provided with connections 10 and 12 for connection into an oscillator circuit (not shown).

As can be seen from Figure 2, a coil oscillator circuit 2.1 generates a signal 2.2 of varying frequency. An adhesive dispenser is fitted into the centre of the coil of the circuit 2.1, to form the core. The signal 2.2 is fed to a phase locked loop circuit 2.3 which performs the conversion from frequency to voltage. Since the output range from the circuit 2.3 is quite small, typically of the order of 30 mVolts, it is necessary to amplify this output. Where the output ranges from V_{min} to V_{max} , the output signal is amplified at the amplifier 2.4 while referenced to V_{min} . In practice, for example where the output range is typically of the order of 30mV, the minimum voltage V_{min} would be 5 volts and the maximum voltage V_{max} would be 5.03 volts. For analogue to digital conversion in the converter 2.5, a range of about 2.5 volts is required. The signal from 2.3 is fed into a difference amplifier 2.4 with 5 volt signal on the second input, and amplified 80 times. This will give an output range of 0 volts to 2.4 volts, which is then fed into the analogue to digital converter 2.5. The digital output of the converter 2.5 is fed via an interface 2.6 to a microprocessor 2.7.

As is shown in Figure 3, the signal 2.2 of varying frequency fed to the frequency to voltage converter 2.3 is converted to a voltage output. The frequency a corresponds to the frequency of the coil when the tube of adhesive is full, and is converted to the maximum voltage V_{max} . The frequency b corresponds to the frequency of the coil when the tube of adhesive is empty, and is converted to the minimum voltage V_{min} .

In operation, a dispenser in the form of a syringe containing adhesive medium is inserted

into the sheath 1, from the open end 2, with its nozzle protruding through the hole 6.

The microprocessor 2.7 can be programmed to indicate to the operator when the supply of adhesive is about to run out, or to give an indication of how many more bonding cycles can be carried out before the supply has to be replaced or refilled.

The sensor and method according to the invention are particularly suitable for use when the adhesive is an epoxy adhesive.

The sensor according to the invention can be used using differently sized dispensers, with correspondingly differently sized sheaths.

In surface mount machines, the adhesive dispensers used are typically syringes having capacities of 10ml, 20ml or 35ml. In the case of a 10ml syringe, the sheath has an internal diameter of approximately 18mm and a length of approximately 75mm. For a 20ml syringe, the sheath has an internal diameter of approximately 20mm and a length of approximately 95mm, and for a 35ml syringe, the sheath has an internal diameter of approximately 25mm and a length of approximately 105mm. The coils embedded within the different sheaths are manufactured to have the same inductance, independent of size. This is achieved by using an appropriate gauge of wire and number of turns. Although nominally of the same inductance, fine tuning is used for the different coils.

Claims

1. A sensor for sensing the level of adhesive medium in a dispensing device, characterised in that the sensor comprises;

(a) a coil which is adapted to surround a dispensing device for dispensing adhesive medium at an adhesive dispensing station;

(b) means for connecting the coil to the input of an oscillator;

(c) detector means for detecting the frequency of the output of the coil;

(d) conversion means to perform a frequency to voltage conversion on the varying frequency detected at the detector means (c);

(e) analogue to digital conversion means to convert the signal from the frequency to voltage conversion means (d) into a form which can be compared with a calibration scale obtained by measuring the signals generated at the output of the coil, when the coil is surrounding a dispensing device containing at least two different known quantities of adhesive medium; and

(f) display means for displaying the result of this comparison.

2. A sensor according to claim 1 characterised in that the conversion means (d) comprises a phase

locked loop circuit.

3. A sensor according to claim 1 or claim 2 characterised in that it further comprises an amplifier which amplifies the output signal from the frequency to voltage converter (d) before it is fed to the analogue to digital converter (e). 5

4. A method for sensing the level of an adhesive medium in a dispensing device, characterised in that the method comprises the steps of;

- (i) surrounding the dispensing device with a coil; 10
- (ii) using the coil as the frequency determining component of an oscillator;
- (iii) detecting the frequency of the output of the coil at at least two different known levels of adhesive, in order to calibrate the coil; 15
- (iv) detecting the frequency of the output of the coil at the level of adhesive which is required to be sensed;
- (v) comparing the frequency detected in step (iv) with the calibration of step (iii); and 20
- (vi) calculating the level of adhesive in the dispensing device.

5. A method according to claim 4, characterised in that the frequency detected at (iii) and (iv) is put through a frequency to voltage converter. 25

6. A method according to claim 5, characterised in that the frequency to voltage converter is a phase locked loop (PLL) circuit.

7. A method according to claim 5 or claim 6 characterised in that the output from the frequency to voltage converter is amplified in a difference amplifier. 30

8. A method according to claim 7, characterised in that the amplified voltage signal is fed to an analogue to digital converter. 35

9. A method according to any of claims 4 to 8, characterised in that the adhesive is an epoxy adhesive.

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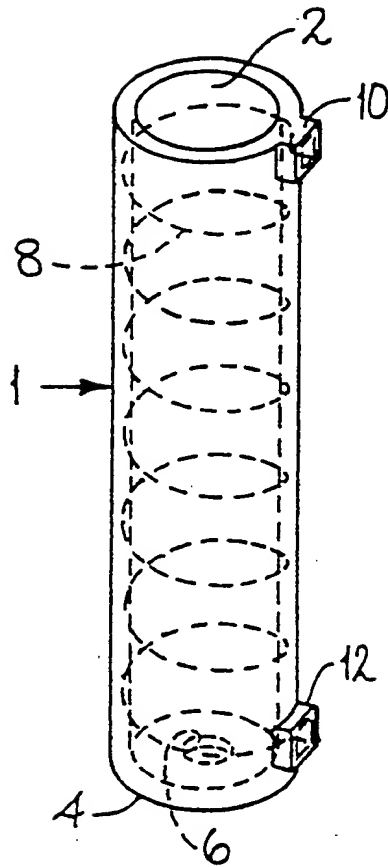


Fig-1

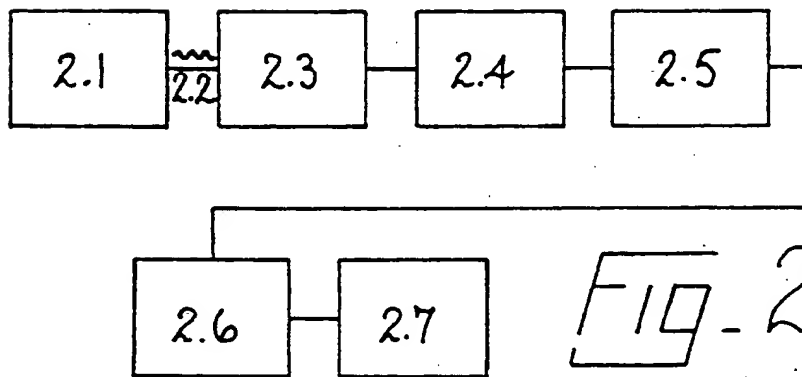


Fig-2

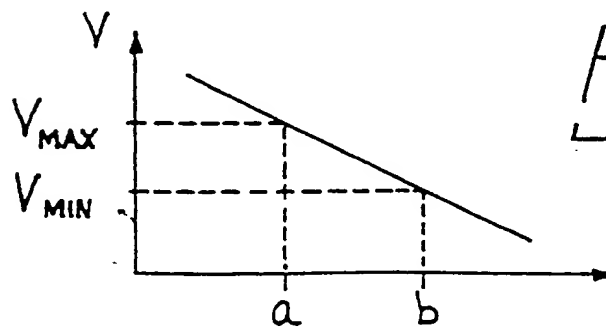


Fig-3